

March 4

Work Order ID 141462

141462

Page 1

Item ID: D4131-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Front Plate

Stop *NS2*

Start Date: 2/3/2016 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: hcs Date: FEB 05 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4131	C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

(2) _____ 2/16/02/25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(2) _____ 2/16/02/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Picklist Print

Friday, February 05, 2016 7:56:20 AM

Page 1

Work Order ID: 141462

141462

Parent Item: D4131-1

D4131-1

Parent Item Name: Front Plate

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	312.6900	0.1807	0.380421			

M304S18GA

304/316 .050 Sheet

02/16/02/25

Location

Loc Qty

Loc Code

MAT020

304.99

M132797

4.99

M133328

180

M133587

120

MAT20

7.7

M131700

7.7

DQA: _____ Date: _____

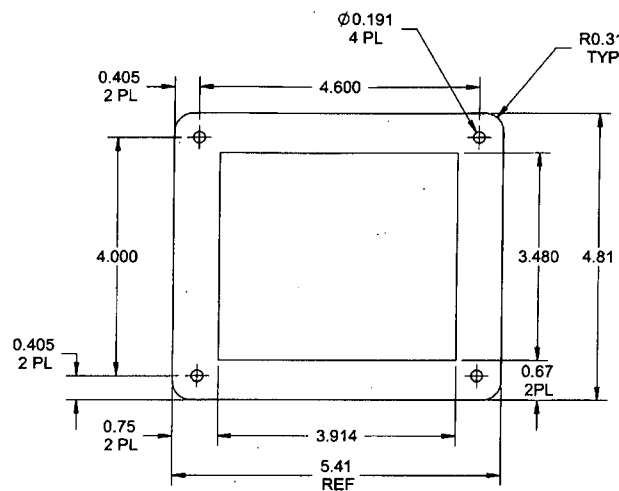


WORK ORDER NON-CONFORMANCE / UPDATE

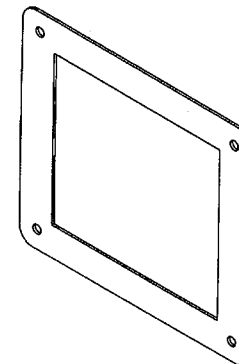
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐		Operator ☐	Bending ☐		Set-up ☐		Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐	Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	Part Incorrect ☐	
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐		Use for Testing ☐	Cuffs ☐		Contamination ☐		Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐		Poor Information ☐	Crushing ☐		Countersink ☐		Off-set ☐	Drawing ☐	
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Finish ☐	
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	Misread ☐	
Substation ☐		Process Improvement ☐	Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____						
Misidentified ☐		Past Due ☐							



D4131-1 FRONT PLATE



NOT A COPY
 INTO
 DRAWING
 OLD COPY
 ELEMENT
 FORCE
 141462 MJS
 16-02-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

RELEASED
 2014-10-20

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4131	REV. C
	MFG. APPR.	JFS	SHEET 5 OF 10	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
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